Work Order ID 1 June-03-14 7:11:50 AM	120027		*17()						Page 1
Item ID: D3391-02.	5		Accept	*N900	040	100)*	_	art *\	IS1*
Item Name: Aft Tube A	ssembly		•					St	top *\	IS2*
Start Date: 6/03/14	Start Qty: 1.00	*1*		Cust Item	ID:					
Required Date: 6/03/14	Req'd Qty: 1.00	*1*	4	Customer:						42.
Reference:		•							•	
Approvals: Process F	Plan: MLJ	Date: 14-06-03	Tooling:	D	ate:				art *N	IR1*
QC:		Date:	_ SPC (Y/N):	D	ate:			51	op *N	IR2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr R	evision Nbr	1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1								
D3391 · I)					٠٠,
Mori Seiki Mori Seiki CNC Lathe Large	_	HE LARGE Folio FA599 Rev VE STEADY REST AND	0.00 PAGO A & DWG-D3391 Rev: MACHINIG-MARKS**					φ	\$	19/08/ 19/08/
110	QC2- Inspect parts off m	achine FAI/FAIB	0.00						_	
*11 0 *	Memo		0.00					-\$	<u> </u>	- <u> </u>
Quality Control								ŕ		14/80/41
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112	QC5- Inspect part compl	eteness to step on W/O	0.00							DAS
*11 2 *	Memo		0.00				\mathcal{D}) <u> lu.c</u>	76.72	9 9-89

Quality Control

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						WORK ORDER NON	-CC	ONFO	RMANC	E / U					AEROSPACE
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Work Orac	•					Rework	۱ ۱		Skid-tube		Crosstube		Water Jet		Engineering
Part N	lo.					Scrap	1		Machining	_	Small Fab	Pro	d. Eng. Coor.		Quality
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	Crushing Heat Treat					Countersink Cut Too Short	-	Mislabe	gned/off c	enter	-	Power Loss/	-		ther
	Inspection Strip in Tube					4	-	Misrea			L	Trower ross/	Juige		
				oune	·	Drawing Drill Holes	\vdash	Off-set							
	-	Marks/Ch Turning S			-	Finish	-	4	Calibration						
		Wave/Tw			_	Fit/Function	\vdash	4	Sequence						

Work Ord June-03-14 7:1		120027		*120)()/27*							Page 2
Item ID: Revision ID: Item Name:	D3391-0			Accept	*N900	040	1100) *	Setup	Start Stop	171	S1* S2*
Start Date: Required Date: Reference:	6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					14	. 1/
Approvals:	Process QC:	Plan:		Tooling: SPC (Y/N):		nte:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II 120 *1 O A HAAS 1 HAAS CNC vertica		Operation Description HAAS CNC VERTICAL Memo 1-Machine a 2-Deburr		Set Up/ Run Hours 0.00 0.00 A Dwg D3391 Rev:	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
*130 *130* QC Quality Control		QC2- Inspect parts off m Memo	achine FAI/FAIB	0.00] D m /10,	/u		(
140 *1 		QC8- Inspect parts - seco	and check	0.00						<u> </u>		DAS 44 4 / (0 / /

Quality Control

INSPECT INSIDE BORE

DQA:			Date:			_								"A DT
						WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only		
Work Orde	er:					DISPOSITION		*	AGAINST	DE	PARTMENT	/PROCESS		
	-					Rework			Skid-tube Crosstube	11	•	Water Jet		Engineering
Part N	lo.					Scrap		1	Machining Small Fab		Pro	d. Eng. Coor.		Quality
	-					Use-as-is		Thern	noforming Finishing		Rec/Sto	re/Packaging		Other
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Root					Desc	ription of work order update		Initial	Action		Sign &			11111
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	Crimp/Kink/Ripple/Wave				<u> </u>	Burrs		1	ion Incomplete/Unqualified	<u> </u>	Part Lost/Mi	ssing	_	Weld
	Cuffs				<u> </u>	Contamination		4	cions Incomplete/Unclear		Part Moved		Ш'	Wrong Stock Pulled
	_	Crushing			<u> </u>	Countersink		4	ned/off center		Positioned V			
	-	Heat Trea			<u> </u>	Cut Too Short		Mislabe			Power Loss/	Surge		Other
	$\overline{}$	Inspection		Tube		Drawing		Misread						
	-	Marks/Ch				Drill Holes		Off-set						
		Turning S	-			Finish		₹	Calibration					
		Wave/Tw	ist in Tub	e	1	Fit/Function*	l	Out of S	Sequence					

June-03-14 7:11:50 AM Accept 4 D3391-025 *N900040100* Item ID: Setup Start **Revision ID: Item Name:** Aft Tube Assembly **Start Qty:** 1.00 *1* **Start Date:** 6/03/14 **Cust Item ID:** Required Date: 6/03/14 **Reg'd Oty:** 1.00 *1* **Customer:** Reference: Run Process Plan: Date: **Tooling:** Approvals: Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept **Work Center ID Description Run Hours** Code Qty 150 0.00 Skidtubes *150* Skidtubes 0.00 Memo 1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803 Skidtubes **160** 0.00 BENDING MACHINE - SKIDTUBES *160* CNC Bend 1 0.00 Memo CNC Delta 100 Bender Form as per Dwg D3391 Using Bend Prog 3391025 170 QC5- Inspect part completeness to step on W/O 0.00 *170* 0.00 Memo Quality Control

Stop

Stop

Reject

Insp.

Number Stamp

Reject

Qty

H-4.2"

DQA: 🥂 📜	•	Date	::		WORK ORDER NON	-C(ONFOI	RMANCE / U	IPDATE			•	DART
QA Closed:		Date	::							ork Order up	odate only		
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N				_	Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root			1	Desc	ription of work order update		nitial	Ac	tion	Sign &			
Cause	Da	te Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification		QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved				N					•				
				· · · · · ·		FAI	ULT CAT	TEGORY					***
Landir	anding Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence General Bend BoM/Route Broken/Damage/Defect Contamination Countersink Cut Too Short Drawing Drill Holes Finish				Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/U ions Incomplete/ gned/off center eled		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/S	tolerance ci ssing Vrong	S T V V	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		ing Sequenc e/Twist in Tu		 	Fit/Function	\vdash	4	Calibration Sequence					

Memo

120
Skidtubes

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

0.00

7-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig.

******Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.297" and c'bore as per dwg D3391

6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.

7-Deburr

8- Scribe batch # on fwd end

/U-10-15.

PTO

Insp.

Stamp

Page 4

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DQA:	Aut	Date:	14(1	2/08		BL C	ONEO		IDDATE			DART
QA Closed:	ZAAS,	Date:	14/	12/	WORK ORDER NO	N-C	JNFO	RIVIANCE / U		Work Order u	pdate only	AEROSPACE
Work Order	12 M	22 7			DISPOSITION				AGAINST I	DEPARTMENT	/PROCESS	
Part No). <u>D33</u>	91-6)25		Rework Scrap Use-as-is Suspected Unapproved			Skid-tube X Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
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Cause	Date	Step	Qty	1.0	or non-conformance		nief Eng	Desc	ription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	14-10-15	150		C-bo	CBZ, Employee coad To deep. 130' leaving to little lateral to accomodant. Employe not follow; The instructi /LOA.	b to	J/5/14	No REPL	~	DGC 14-10-16	14-10-16	- Mholis
						FA	ULT CA	TEGORY				
Landing	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misrea Off-set Out of	cion Incomplete/U tions Incomplete/ gned/off center eled d	·	Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	tolerance ct issing Wrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
- 1	Wave/Tw	ist in Tub	e e		Fit/Function	1	IOut of:	Sequence				

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QC

Quality Control

120027

Page 5

June-03-14 7:11:50 AM Accept D3391-025 Item ID: *N900040100* Setup Start **Revision ID:** Stop Aft Tube Assembly **Item Name:** *1* **Start Qty:** 1.00 6/03/14 **Start Date: Cust Item ID:** Required Date: 6/03/14 Req'd Oty: 1.00 *1* **Customer:** Reference: Run Start **Approvals:** Process Plan: Date: Tooling: Date: Stop Date: SPC (Y/N): OC: Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Accept Reject Reject Insp. Work Center ID **Description** Qty Number Stamp **Run Hours** Code Qty 190 QC5- Inspect part completeness to step on W/O 0.00 *190* QC 0.00 Memo Quality Control 200 Chemical Conversion Coat per QSI005 4.1 0.00 *200* HandFinish 0.00 Memo Hand Finishing 210 QC7-Inspect Chemical Conversion Coat 0.00

0.00

Memo

DQA:		ware	Date:											TOART
						WORK ORDER NON	-CO	ONFO	RMANCE / UPDATE				_	AEROSPACE 1
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WOIR OIG	-''-					Rework	1	ŀ	Skid-tube Crosstub	e	1	Water Jet	Г	Engineering
Part N	lo.					Scrap	1	I	Machining Small Fa	_	Pro	d. Eng. Coor.	_	Quality
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	Cuffs				_	Contamination	-	-	tions Incomplete/Unclear	\vdash	Part Moved			Wrong Stock Pulled
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	1	Wave/Tw	ist in Tub	e		Fit/Function	1	Jout of S	Sequence					

Work Ord June-03-14 7:		20027		*120	1 027*							Page 6
Item ID: Revision ID:	D3391-025			Accept	*N900	040	10	N *	Setup		171	S1*
Item Name:	Aft Tube As	ssembly								Stop	*N	S2*
Start Date:	6/03/14	Start Qty: 1.00	*1*		Cust Item 1	ID:						
Required Date Reference:	e: 6/03/14	Req'd Qty: 1.00	*1*		Customer:							
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:			Run	Start	^I <i>V</i>	R1*
	QC:		Date:	SPC (Y/N):	D :	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	I D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp
*220		Skidtubes		0.00								
Skidtubes		Memo		0.00				76.5				
Skidtubes		A/R Magn exp. date:_ cure time 12 2- Grind cro	cers as per dwg D3391 abond 6398 Batch: Chrs as per QSI0015 assbolts flush I using #9 drill Magnabond									
²³⁰ *230*		QC5- Inspect part compl	eteness to step on W/O	0.00								
QC		Memo		0.00								

Memo

Quality Control

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_					Rework			Skid-tube	Crosstube]	Water Jet	Engineering	g
۱o					Scrap			· —	Small Fab		· · · · · · · ·		` ——
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۱٥.					Suspected Unapproved	<u> </u>		Large Fab	Composite	J	Supplier		
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	lo.	ng Gear Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspectio Marks/Ch Turning S	Date: Da	Date: Da	Date: Pr:	Date: Disposition Rework Scrap Use-as-is Suspected Unapproved	WORK ORDER NON-Co	WORK ORDER NON-CONFO	Date: Disposition Skid-tube Machining Thermoforming Large Fab	Date Date Description of work order update or non-conformance Description De	Date: DISPOSITION Rework Skid-tube Machining Finishing Rec/Store Composite Machining Composite Machining Composite Machining Composite Machining Composite Machining Composite Machining Composite Machining Composite Machining Rec/Store Composite Machining Composite Machining Composite Machining Rec/Store Composite Machining Rec/Store Composite Machining Composite Machining Rec/Store	Date Disposition Rework Skid-tube Crosstube Small Fab Prod. Eng. Coor. Rec/Store/Packaging Large Fab Composite Date Step Qty Or non-conformance Chief Eng Description Date Step Qty Or non-conformance Chief Eng Description Date D	Date: Disposition Disposition Disposition Disposition Date

Work Orde June-03-14 7:1		20027		*120	1 027*			A STATE OF THE STA				Page 7
Item ID: Revision ID:	D3391-025			Accept	*N900	040	100)*	Setup	Start	*N:	S1*
Item Name:	Aft Tube Ass	embly								Stop	*N:	S2*
Start Date: Required Date:	6/03/14 6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Reference:			-						_	Q		
Approvals:		an:	Date:	Tooling:		ite:			Run	Start Stop		R1*
	QC:		Date:	_ SPC (Y/N):	Da	ıte:				-	*NI	R2*
Sequence ID/ Work Center II 235)	Operation Description Pressure Wash per QSI00	15.4.3	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
935 HandFinish		Memo	J 4.J	0.00								ANT SPECIAL SP
Hand Finishing		AND REAL	ODINE AS PER PAR09-(043								
240		White Gloss(Ref:4.3.5.1)	per QSI005 4.3-Alum	0.00								
940 Powdercoat		Memo		0.00								
Powder Coating			E: PERATURE: E:	-								

0.00

250

Quality Control

QC3- Inspect Part Finish

Memo

DQA:			Date:											DART			
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UP		W	ork Order uj	odate only	AERŌSPĀCĒ			
						DISPOSITION						PARTMENT					
Work Ord	er: .											7	_				
5						Rework			Skid-tube	Crosstube		J	Water Jet	Engineering			
Part I	۷O. _.					Scrap Use-as-is			Machining noforming	Small Fab Finishing	_	4	d. Eng. Coor. re/Packaging	Quality Other			
NCR I	۷o.					Suspected Unapproved		illeli	Large Fab	Composite	_	1,667310	Supplier				
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Root					Desc	ription of work order update		nitial	Acti	on		Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	QC Inspector			
Design																	
Doc/Data																	
Equip/Tooling																	
Handling/Pre																	
Material																	
Operator																	
Offset/Setup	Ш																
Process																	
Supplier						:											
Training	Ш																
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							FA	ULT CA	regory								
Landi	ng G	Gear			_	General		,		•		7	_	_			
		Bending			<u> </u>	Bend		1	Program			Outside Dim	ļ	Pressure/Forced			
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route		Grain				Over/Under		Set-up			
		-				Broken/Damage/Defect		Hardwa				Part Incorre	<u> </u>	Temperature/Cure			
		Crimp/Kink/Ripple/Wave			<u> </u>	Burrs		Inspect	ion Incomplete/Und	qualified		Part Lost/Mi	ssing	Weld			
	Cuffs				<u> </u>	Contamination		4	ions Incomplete/U	nclear		Part Moved		Wrong Stock Pulled			
		Crushing				Countersink	Misaligned/off center Positioned Wrong						- -1				
	-	Heat Trea				Cut Too Short		Mislabe				Power Loss/	Surge	Other			
		Inspectio	n Strip in	Tube		Drawing		Misread	t								
		Marks/Ch	natter			Drill Holes		Off-set									
		Turning S	equence			Finish	Out of Calibration										
		Wave/Tw	ist in Tub	e		Fit/Function		Out of									

Work Orde June-03-14 7:1		120027		*120	1 027*							Page
Item ID: Revision ID:	D3391-0)25		Accept	*N900	040	100)*	Setup		*N	S1*
Item Name:	Aft Tube	Assembly								Stop	*N.	S2*
Start Date:	6/03/14	Start Qty: 1.00	*1*		Cust Item 1	D:						
Required Date:	6/03/14	Req'd Qty: 1.00	*1*		Customer:							
Reference:							_		D	Stant		
Approvals:	Process	Plan:	Date:	_ Tooling: _	Da	ate:			Run	Start	*N	R1*
	QC:		Date:	_ SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
260				0.00								
260 HandFinish		HandFinishing Memo		0.00								
Hand Finishing		1-Install inse 2-Install Aft A/ R Sikafle	rts as per Dwg D3391 Cap as per Dwg D3391 x-241/-291 expiry date:	<u>-</u>								
		3- INSTALL	WEARPLATES AS PER	DWG								
270		QC5- Inspect part comple	teness to step on W/O	0.00								
クフハ												
QC Quality Control		Memo		0.00								

0.00

280

280 Packaging

Packaging

Identify as per dwg & Stock Location:_____

Memo

DQA:			_ Date:						_				TAART
						WORK ORDER NON-	-C(ONFO	RMANCE / UPDAT				AEROSPACE
QA Closed:			Date:	. 						W	ork Order up	date only	
Work Ord	er:					DISPOSITION			AC	GAINST DE	PARTMENT	PROCESS	
						Rework	1		Skid-tube Cro	osstube		Water Jet	Engineering
Part I	No.					Scrap				nall Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		1	· —	inishing	Rec/Stor	e/Packaging	Other
NCR I	No.					Suspected Unapproved			Large Fab Con	nposite		Supplier	
	·												
Root					Desci	ription of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Description	1	Date	Verification	QC Inspector
Design				:									
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process						!							
Supplier	_												
Training													
Transport													
Unapproved								IIIT CAT	L TEGORY				
Landi	na G					General	<u> </u>	OLI CA	ILOOKI	· · · · · ·			
Lanui	_	Bending			Г	Bend	Г	leolio/E	Program		Outside Dim	ensions [Pressure/Forced
	┢	Centre No	nt Concen	ntric		BOM/Route	\vdash	Grain	108.4		Over/Under	<u> </u>	Set-up
	\vdash	Cracks	or concen		┢	Broken/Damage/Defect	\vdash	Hardwa	ire		Part Incorred	 	Temperature/Cure
	Н	Crimp/Kir	nk/Ripple	/Wave		Burrs	 	4	ion Incomplete/Unqualifi		Part Lost/Mi	-	Weld
		Cuffs	,	,		Contamination		4	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Г	Crushing				Countersink		4	ned/off center		Positioned W	/rong	_
		Heat Trea	at			Cut Too Short		Mislabe		_	Power Loss/S	_	Other
•		Inspectio		Tube		Drawing		Misread				-	
		Marks/Ch	-			Drill Holes		Off-set					
		Turning S			-	Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Sequence				

Work Orde		20027		*120	1 027*			1.0				Page 9
Item ID: Revision ID: Item Name:	D3391-025 Aft Tube As			Accept	*N900) 040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	6/03/14 6/03/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:							,
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		Oate: Oate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II)	Operation Description QC21- Final Inspection	Work Order Pologo	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
*290 *290*		Memo	- WOIK OIGET REJEASE	0.00								

Memo

Quality Control

Scralbd Scralbd

DQA:			Date:										DART
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UP		/ork Order up	ndate only	AEROSPACE
QA Closed.			Date.							•	rork Oraci ap	date only	<u> </u>
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
		•				Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	١o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Therr	moforming	Finishing	Rec/Stor	re/Packaging	Other
NCR I	۷o.					Suspected Unapproved			Large Fab	Composite		Supplier	
					_				1			· · · · · · · · · · · · · · · · · · ·	
Root				۵.	Desc	ription of work order update	ı	Initial	Acti		Sign &		061
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling	-												
Handling/Pre													
Material		1											
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Transport	Ш												
Unapproved			<u></u>	<u> </u>	<u> </u>		<u> </u>		1				
							FA	ULI CA	TEGORY		·		
Landi	_	7				General]:_/:	\		70	: Г	Pressure/Forced
	\vdash	Bending				Bend	⊢	1	Program		Outside Dim		-
	ļ	Centre No	ot Concer	ntric	\vdash	BOM/Route	\vdash	Grain			Over/Under	 	Set-up
	\vdash	Cracks	. (5)		\vdash	Broken/Damage/Defect	\vdash	Hardwa			Part Incorred	-	Temperature/Cure
	\vdash	Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs	ļ	1 '	ion Incomplete/Un	·	Part Lost/Mi	ssing	Weld
	_	Cuffs				Contamination		4	tions Incomplete/U	nciear	Part Moved	L	Wrong Stock Pulled
		Crushing			<u> </u>	Countersink	\vdash	1 '	gned/off center		Positioned W		Tothor
	-	Heat Trea		- 1	\vdash	Cut Too Short	L	Mislabe			Power Loss/	Surge [_	Other
	-	Inspectio	•	lube		Drawing	<u> </u>	Misrea					
:		Marks/Ch			<u> </u>	Drill Holes	_	Off-set	, X*		-		
		Turning S	-		<u> </u>	Finish	<u> </u>	4	Calibration		-		
		Wave/Tw	ist in Tub	e		Fit/Function	<u> </u>	Out of S	Sequence				

Picklist Print

June-03-14 7:11:54 AM

Work Order ID: 120027

120027

Parent Item:

D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

ECN773 dwg rev. D EC IPP Rev B 06-02-07

IPP Rev:C 06-03-28 Update Manuf. Instructions JLM

07.03.20 IPP rev D

revF dwg EC

07.11.07 IPP rev E

rev G dwg ecn 1053p EC verified by: DD DD verified by: EC

IPP Rev:F 07-11-13

ECN 1056

IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H

11.11.14 AS PER REV.I DD verified by:JLM

				Location	Seq ID	Measure	Hand			Total Qty	Qty Issued	Date Issued	Status
	Manufactured	No			260	Each	14.0000		1	1			19.6
*								**	_				
			Location		Loc	<u>Oty</u>	Loc Code						
			FP001			14					_		
				102241		2					_		
				108289		12					_		
	Manufactured	No			260	Each	9.0000		l	1			
*								**					
			Location		Loc	Qty	Loc Code						
			FP001			9							
				109670		9			_		_		
	Manufactured	No			100	Each	63.0000	1		1			
*								**	_				
			Location		Loc	<u>Oty</u>	Loc Code						
			LG003			63					_	1 17	/ /
				_						/	-mm	L 14/	08/18
		M anufactured	Manufactured No	Manufactured No Location FP001 Manufactured No Location LG003	102241 108289 Manufactured No Location FP001 109670 Manufactured No Location LG003 79742	102241 108289 Manufactured No 260 Location Loc FP001 109670 Manufactured No 100 Location Loc 10003 79742	102241 2 108289 12	102241 2 108289 12	102241 2 108289 12	102241 2 108289 12	102241 2	Manufactured No 102241 2	Manufactured No 260 Each 9.0000 1 1

. 5.

DQA:			Date:										TOAR	T
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA		l. O l		AEROSPA	4 C E
QA Closed:			Date:						· · · · · · · · · · · · · · · · · · ·	W	ork Order up	date only		
Work Orde	er:					DISPOSITION	•		A	GAINST DE	PARTMENT	/PROCESS		
					_	Rework			Skid-tube Cro	osstube	7	Water Jet	Engineering	7
Part N	No.					Scrap				nall Fab	Pro	d. Eng. Coor.	Quality	-
	_				_	Use-as-is			· —	inishing	-4	re/Packaging	Other	7
NCR N	No				'	Suspected Unapproved			* H	mposite]	Supplier] [ı
Root	Ţ				Desci	ription of work order update		nitial	Action		Sign &		<u> </u>	
Cause		Date	Step	Qty		or non-conformance	ı	ief Eng	Description	n	Date	Verification	QC Inspecto	or
Design			• • •											
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator							ŀ							
Offset/Setup														
Process														
Supplier			ļ ·											
Training														
Transport														
Unapproved														
							FAI	ULT CAT	TEGORY					
Landi	ng Ge	ar			_	General				_	7	_	_	
	В	ending				Bend		1	rogram		Outside Dim		Pressure/Forced	
	\square	entre No	ot Concer	ntric	_	BOM/Route		Grain			Over/Under		Set-up	
					Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorred	-	Temperature/Cu	re	
	Crimp/Kink/Ripple/Wave		Burrs		1 '	on Incomplete/Unqualif		Part Lost/Mi	ssing	Weld				
	_	uffs				Contamination	L_	4	ions Incomplete/Unclea	ır 📙	Part Moved	L	Wrong Stock Pull	ed
	-	rushing				Countersink	-		ned/off center	ļ	Positioned W			
	—	leat Trea				Cut Too Short		Mislabe			Power Loss/S	Surge	Other	
	_	-	n Strip in	Tube		Drawing		Misread	i					
	\vdash	/larks/Ch				Drill Holes	-	Off-set						
	—	-	equence			Finish	-	1	Calibration					
	i Iv	Vave/Tw	ist in Tub	e	1	Fit/Function	l	Out of 9	Sequence					,

Work Order ID: 120027

120027 D3391-025

Parent Item Name: Aft Tube Assembly

D3391-025

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Parent Item:

Manufactured

Manufactured

230

232.0000 Each

**

D3670-4-200

Bushing

Location	<u>1</u>	Lo	c Oty	Loc Code			
FG			10				
	87709		10			***************************************	
LG001			222				
	103880		15				
	109108		206				
	96240		1				
		270	Each	62.0000	1	1	

D2646

D2646

Aft Cap

Location	Loc Oty	Loc Code
FG	4	
85848	2	
90495	2	
FP001	58	
103306	3	
107857	1	
110816	13	

31

10

**

113830

114495

DQA:			Date:											DART
						WORK ORDER NON	-C(ONFO	RMANCE / U		(a.d. O.d.a			AEROSPACE
QA Closed:			Date:					·		V	ork Order up	date only		
Work Orde	r.					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
WOIR OIGE	·· –					Rework	1		Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	ο.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	\sqcap	Quality
	_					Use-as-is	1		noforming	Finishing		e/Packaging	П	Other
NCR N	ο.					Suspected Unapproved			Large Fab	Composite		Supplier	_	
								<u> </u>			-	·		
Root					Desc	ription of work order update		Initial	Act	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	₁	QC Inspector
Design	_												İ	
Doc/Data	_		ļ											
Equip/Tooling													Ì	
Handling/Pre														
Material	_						Ì							
Operator	_													
Offset/Setup	_													
Process														
Supplier	_													
Training	_						}							
Transport	_				1									
Unapproved						-								
							FA	ULT CAT	EGORY					
Landin	_				Г	General]		Γ_	70		$\overline{}$	D
-	_	Bending			-	Bend	\vdash	-	rogram	<u> </u>	Outside Dim		-	Pressure/Forced
-		Centre No	ot Concer	ntric	-	BOM/Route		Grain			Over/Under		-	Set-up
F	_	Cracks	.l./0:l.	///		Broken/Damage/Defect		Hardwa			Part Incorred		-	Temperature/Cure Weld
	_	Crimp/Kir	ік/кірріе	/wave	-	Burrs	\vdash	- 1 '	on Incomplete/Ur	_	Part Lost/Mi	2211.IR		Wrong Stock Pulled
-	_	Cuffs			\vdash	Countamination	\vdash	4	ions Incomplete/l	Inclear	Part Moved	/rong		wrong Stock Fulled
	\neg	Crushing			\vdash	Countersink	\vdash	Mislabe	ned/off center	-	Positioned V Power Loss/	-		Other
		Heat Trea		Tuka	-	Cut Too Short	-	4		L	Trower rossy:	onige		Outer
	_	nspectio	-	rupe	<u> </u>	Drawing	-	Misread	ı					
-		Marks/Ch			<u> </u>	Drill Holes	\vdash	Off-set	Calibration					<u></u> ,
		Turning S Nave/Tw	•		-	Finish Fit/Function	-	-1	Calibration Sequence			**** *********************************	—	
	- 11	/vave/ i W	ารเสา เนเ	/ C		IT IL/ FUITCUOII		1001013	requence					

Work Order ID: 120027

Parent Item:

120027

D3391-025

Parent Item Name: Aft Tube Assembly

D3391-025

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00 2

**

Required Qty: 1.00

D3672-1

Manufactured

270

Each

1,238.000

D3672-1

Phenolic Washer

Location	Lo	c Oty	Loc Code		
FG		10			
85222		10			
Return2014		34			
80369		34			
ST060		1194			
103845		4			
112218		500			
113581		500			•
93886		62			
99099		128			
	260	Each	7,504.000	14	14

ALS4-1032-130

AELS4-1032-130 Purchased

No

**

AI S4-1032-130

Location	Loc Qty	Loc Code	
FP001	7399		
M128649	7399		
ST279	48		
M128211	48		-
st510	57		
M126109	57		

DQA:	Date: WORK ORDER NON-CONFORMANCE / UPDATE								DART						
OA Classel			Datas			WORK ORDER NON	-C(ONFO	RMANCE / U		Mark O	rdor ur	odate only		AEROSPACE
QA Closed:			Date:			T	-	<u> </u>			WOIR O	ruer up	date only	Щ.	
Work Orde	er:					DISPOSITION				AGAINST I	DEPART	MENT	/PROCESS		
	•					Rework	1		Skid-tube	Crosstube	7		Water Jet		Engineering
Part N	io.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	-					Use-as-is		Thern	noforming	Finishing	T R	ec/Stoi	re/Packaging		Other
NCR N	١ο. ِ					Suspected Unapproved			Large Fab	Composite			Supplier		
									,						
Root					Desc	ription of work order update	ı	Initial		tion	_	gn &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	D	ate	Verificatio	n	QC Inspector
Design															
Doc/Data							Ì						:		
Equip/Tooling															
Handling/Pre									,						
Material	\dashv														
Operator	_														
Offset/Setup	Ш						Ì				ļ				
Process	Щ			:							l				
Supplier	Щ														
Training															
Transport	\square														
Unapproved			<u> </u>					=	5000						
							FA	ULI CAI	TEGORY						
Landii	$\overline{}$					General];_/n		Г		ida Dim	ensions	\Box	Pressure/Forced
		Bending			-	Bend BOM/Bouto	-	1	rogram	}			tolerance		Set-up
	_	Centre No	ot Concer	ntric	-	BOM/Route		Grain		}		Incorrec		$oldsymbol{oldsymbol{ o}}$	Temperature/Cure
	\blacksquare	Cracks	. l. /D:l.	/\4/=	-	Broken/Damage/Defect	-	Hardwa		ngualified	_	Lost/Mi		\vdash	Weld
	-	Crimp/Kir	ік/кірріе	/ wave	\vdash	Burrs	-	1 '	ion Incomplete/Ui ions Incomplete/U	·	_	Moved	22111B	-	Wrong Stock Pulled
		Cuffs			\vdash	Countarink	\vdash	4	ned/off center	officiear	_	ioned V	Vrong	Ш	Wiong Stock Fulled
	—	Crushing			<u> </u>	Countersink Cut Too Short	\vdash	Mislabe		}		er Loss/:	_		Other
	_	Heat Trea		Tubo	\vdash	4	-	Misread		L		EI LUSS/.	Juige	L,	Juinet
	$\overline{}$	Inspection Marks/Ch		rube	\vdash	Drawing Drill Holes	<u> </u>	Off-set	a .						
	-	Turning S			\vdash	Finish	\vdash	•	Calibration						
	_	Wave/Tw			\vdash	Fit/Function	_	1	Seguence						
		**************************************	Lat III IIII	J C.		TI TO LUITUUT		TOUL UI	ACMUCITED.						

Picklist Print

June-03-14 7:11:54 AM

Page 4

Work Order ID: 120027

Parent Item:

D3391-025

Parent Item Name: Aft Tube Assembly

120027

D3391-025

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

AELS8-1032-225 Purchased

270

Each

727.0000

**

AI S4-1032-225

Rivnut

Location	Loc Oty	Loc Code	
FG	30		
M127028	30		
FP001	423		
M128649	423		M8-994
ST280	248		
M127028	10		
M128179	238		
st555	26		
M127092	26		

DQA:			_ Date:				_						TOA!	T
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UP		ork Order up	odate only	AEROS	PACE
***************************************						DISPOSITION	TION AGAINST DEPARTMENT/PRO				/PROCESS			
Work Ord	er:					Rework			Skid tubo	Crosstube	7	Water Jet	Engineering	
Part I	Part No.				Scrap Use-as-is		Machining Sma		Small Fab Finishing	Prod. Eng. Coor Rec/Store/Packaging		Quality	·П	
NCR I	NCR No.				Suspected Unapproved		men	Large Fab	Composite] (10,310)	Supplier			
Root					Desc	ription of work order update	l	nitial	Actio	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	ption	Date	Verification	QC Inspec	tor
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process		1					ŀ							
Supplier														
Training														
Transport]												
Unapproved		1					l							
							FAI	ULT CAT	TEGORY				·	
Landi	ng (Gear				General		,						
		Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Force	d
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	:ાં	Temperature/C	Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	Weld	
		Cuffs		•		Contamination		1	ions Incomplete/Ur		Part Moved		Wrong Stock Pu	ulied
		Crushing				Countersink		1	ned/off center		Positioned V	/rong		
	—	Heat Trea	at			Cut Too Short	_	Mislabe			Power Loss/S		Other	
		Inspectio		Tube		Drawing	_	Misread		<u>. </u>		- [
	\vdash	Marks/Ch				Drill Holes	-	Off-set						
	Turning Sequence					Finish		4	Calibration		-			
		Wave/Tw				Fit/Function			Sequence				· · · · · · · · · · · · · · · · · · ·	·
L		<u> </u>												

Work Order ID: 120027

120027 *D3391-025*

Parent Item:

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

Purchased

No

No

270

Each 2,750.000 6

**

6

AN3C4A

Loc Oty Location Loc Code FG 20 122814 20 Return2014 124221 9 ST350 13 125388 3 M128606 M128739 ST350/513 26 M128606 26 ST512 3 124221 3 ST513 2679 M127410 1 M127832 62 M128634 616 2000 M128879

Each

600

991.0000

**

AN3C5A

AN3C5A

Bolt

Location Loc Qty Loc Code FG 5 122800 5 ST350 386 M128973 186 M129198 200 ST513 600

270

 _			
		_	

M128911

DQA:	A: Date:					- DART									
						WORK ORDER NON	-C(ONFO	RMANCE / U					AEROSPACE	
QA Closed:			Date:			T					ork Order up	odate only			
Work Orde	er.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS			
work order.					Rework Skid-tube				Crosstube	1	Water Jet	ГΠ	Engineering		
Part No.				Scrap		Machining Small			\vdash			Quality			
	_					Use-as-is			noforming	Finishing	→	re/Packaging	П	Other	
NCR N	No				_	Suspected Unapproved			Large Fab	Composite]	Supplier			
Root			I		Desc	ription of work order update		Initial	Act	ion	Sign &		Т		
Cause		Date	Step	Qty		or non-conformance		ief Eng	Descr	ription	Date	Verificatio	n	QC Inspector	
Design														· · · · · · · · · · · · · · · · · · ·	
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator															
Offset/Setup															
Process															
Supplier			!												
Training															
Transport															
Unapproved															
							FA	ULT CAT	TEGORY						
Landi	ng Ge	ear			_	General					7		_		
		Bending			<u> </u>	Bend		1	rogram	_	Outside Dim		\vdash	Pressure/Forced	
	Щ	Centre No	ot Concer	ntric	<u> </u>	BOM/Route	_	Grain			Over/Under		-	Set-up	
		cracks			L	Broken/Damage/Defect		Hardwa			Part Incorred		\blacksquare	Temperature/Cure	
	Щ	crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs		4 '	ion Incomplete/Ur	· —	Part Lost/Mi	ssing	-	Weld	
	Щ	Cuffs				Contamination		4	ions Incomplete/L	Jnclear	Part Moved		∐ \	Wrong Stock Pulled	
		crushing			<u> </u>	Countersink	_	4 -	ned/off center		Positioned V	-			
	—	leat Trea				Cut Too Short	_	Mislabe			Power Loss/	Surge		Other	
	—	•	n Strip in	Tube		Drawing	L	Misread							
	-	Marks/Ch				Drill Holes		Off-set				,			
	-	_	equence			Finish		Out of 0	Calibration						
	Ιİν	Nave/Tw	ist in Tub	e e		Fit/Function	l	Out of S	Sequence						

Work Order ID: 120027

Parent Item:

D3391-025

Parent Item Name: Aft Tube Assembly

120027 *D3391-025*

m127831

Start Date: 6/03/14

Required Date: 6/03/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

270

5,404.000 Each

10

**

10

NAS1149C0332R

WASHER

Location	Loc Qty	Loc Code	
GA	825		
125654	825		
Return2014	41		
122063	41		
ST292	1380		
124580	8		
125654	8		
m128591	1364		
st510	3158		
m126319	61		
m127306	2500		
m127410	563		

34

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			WORK ORDER NON	-((JNFUI	KIVIANCE / UF		ork Order up	odate only		AEROSPACE	
Monte Ond						DISPOSITION									
Work Ord	er: -					Downsk .			Skid tubo	Crosstube	7:	Water Jet	\neg	Engineering	
Part N	Part No.				Rework Scrap Use-as-is	ap Machining			Small Fab Finishing	Prod. Eng. Coor. Rec/Store/Packaging			Quality Other		
NCR I	NCR No.				Suspected Unapproved		Inem	Large Fab	Composite		Supplier				
Root					Desc	ription of work order update		Initial	Acti	ion	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	<u>1</u>	QC Inspector	
Design															
Doc/Data	Щ														
Equip/Tooling			[-		1						
Handling/Pre	Ш						1								
Material	Ш														
Operator	Ш														
Offset/Setup	Ш						Į								
Process							1		•						
Supplier														~	
Training						•									
Transport	Ш													·	
Unapproved															
						*:	FA	ULT CA	TEGORY	*				·	
Landi	ng G	iear			_	General		,		· /	7	г		1	
	Ш	Bending				Bend	<u></u>	Folio/F	Program		Outside Dim	†		Pressure/Forced	
		Centre No	ot Concer	ntric	L	BOM/Route		Grain,	<i>*</i>		Over/Under	+	-	Set-up	
46		Cracks			L	Broken/Damage/Defect	L	Hardwa	are	<u></u>	Part Incorre	ci	_	Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	issing	-	Weld	
		Cuffs				Contamination		Instruct	tions Incomplete/U	Inclear	Part Moved	Į		Wrong Stock Pulled	
		Crushing				Countersink		Misalig	gned/off center	L	Positioned V	· ·		•	
		Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other	
		Inspection	n Strip in	Tube		Drawing		Misread	d						
		Marks/Ch	atter			Drill Holes		Off-set		~	·				
		Turning S	equence			Finish		Out of	Calibration						
*	\Box	Wave/Tw	ist in Tuk)e		Fit/Function		Out of	Seauence						

DART AEROSPACE LTD	Work Order:	120027
Description: Float Skidtube (412)	Part Number:	D3391-3
Inspection Dwg: D3391 Rev: I		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

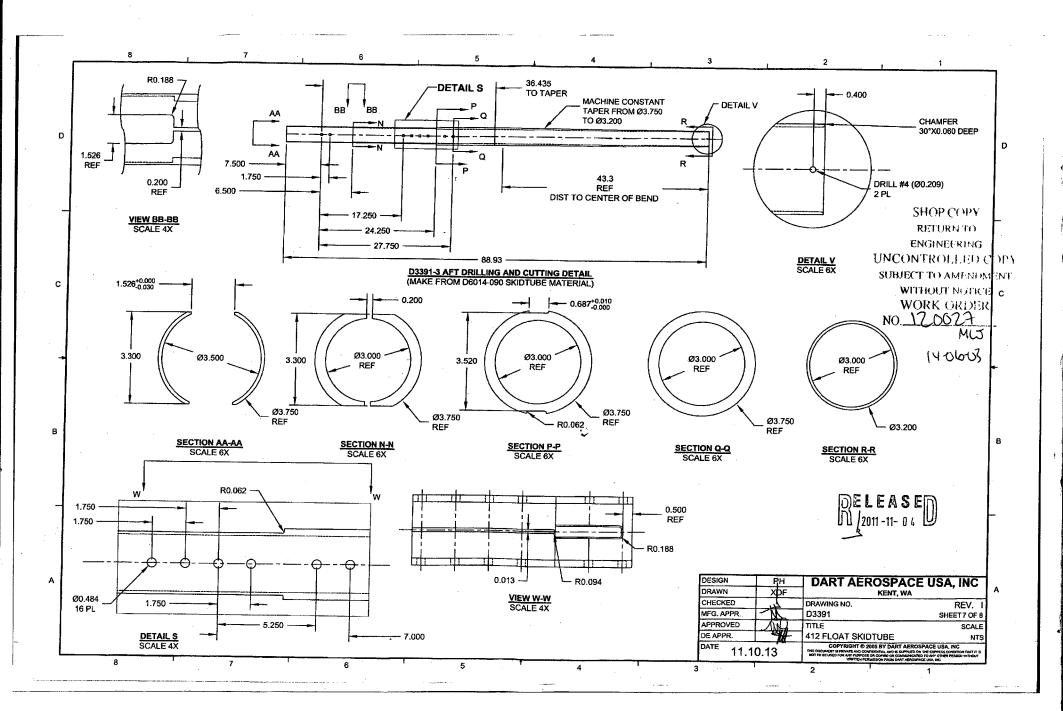
Drawing Dimension	**Tolerance	Prance Actual Ac		Reject	Method of Inspection	Comments		
.a. Li		Lat	he Section	1				
14.000	+/-0.010	14.000			tope	LG-11		
3.500	+/-0.010	3.503			vem	en - 08		
Ø3.200	+/-0.010	3.202)			
Ø3.750	+/-0.010	3.750						
30° x 0.060 chamfer	+/-0.010	30° ×,060	/		J	,		
88.93	+/-0.030	88.936	/		tape	V6-11		

	· /	
Measured by: Min (Date: 14/08/19	
Audited by:	Date:	

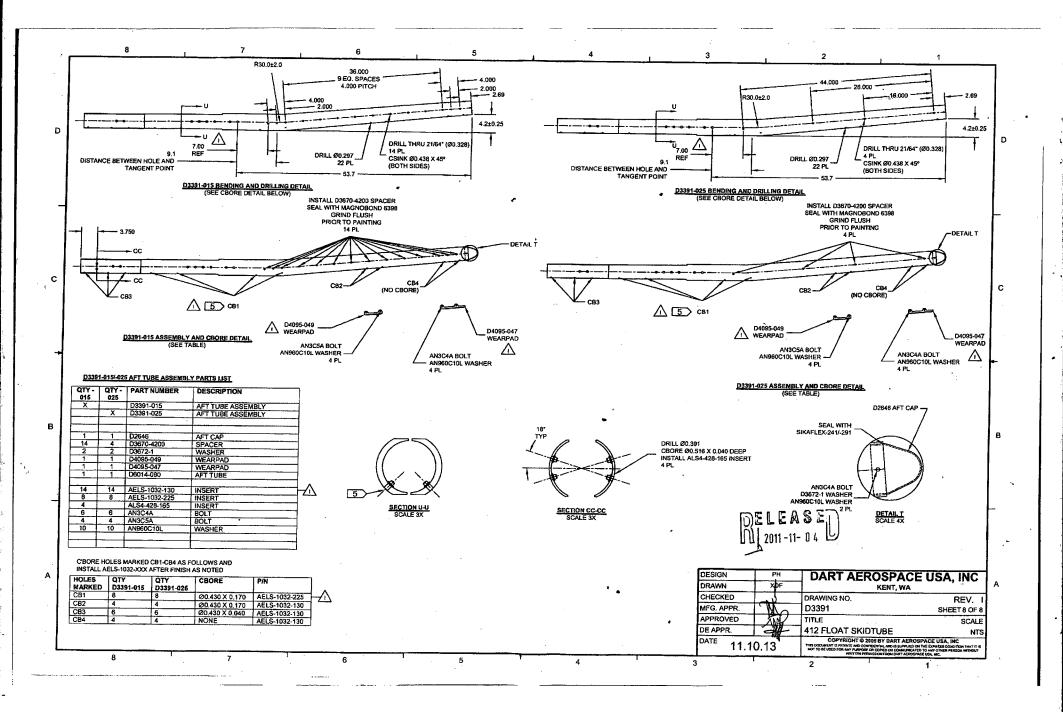
		HAAS Sect	ion
1.526	+0.000/-0.030	1.514	Vern LADS
7.500	\$ +/-0.010	7.895	Haac I
27.750 🐣	+/-0.010	27-750	
31.750	+/-0.010	31.754	
35.250	+/-0.010	35.263	
3.300	+/-0.010	3,302	Vern LP09
0.200	+/-0.010	,2h	
3.520	+/-0.010	3576	
0.687	+0.010/-0.000	.685	
R0.062	+/-0.010	R.062	
Ø0.484	+0.005/-0.001	484	1 1/

Rev	Date	Change	Revised by	Approved
Α	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
В	06.06.19	Dwg revision update	KJ/JLM	
С	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
. Н	11.06.21	Dimension 44.995 removed	KJ	
Ī	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ 10	1.1
L	12.11.28	88.93 dimension added	KJ প	\$4

DQA:			Date:											
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	Wo	ork Order up	odate only	AEROSPACE	
Q. Colosea.			Date.			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Work Orde	er:					DIST 03111014					,			
Part No.				Rework Scrap			Skid-tube Crosstube Machining Small Fab	ŅП	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Quality			
NCR No.				Use-as-is Thermoforming Finishin Suspected Unapproved Large Fab Composit			-	\vdash	Nec/3(0)	Supplier	- Other			
Root					Descr	iption of work order update	ı	nitial	Action		Sign &			
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	n QC Inspector	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved						-								
				<u> </u>			FAL	ULT CA	TEGORY				Market Control of the	
Landir	ng Gear					General		_				_	_	
	Crac Crim Cuff Crus Hea Insp	tre Not ks np/Kink s shing t Treat ection s	Strip in tter	/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misreaa Off-set	ion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled d		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
	Turning Sequence Wave/Twist in Tube				Fit/Function		Out of	Sequence						



DQA:	IA: Date:				DART								
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only AEROSPACE								
		****			DISPOSITION			AGAINST DE	IST DEPARTMENT/PROCESS				
Work Order	:	#1 .c.			n		د المالية المالية	Engineering					
Part No)				Rework Scrap			—	rosstube Small Fab	4	Water Jet d. Eng. Coor.	Quality	
NCR No)				Use-as-is Suspected Unapproved	Therr	~ —	Finishing omposite	Rec/Stor	e/Packaging Supplier	Other		
Root				Desc	ription of work order update		Initial	Action		Sign &			
Cause	Dat	e Step	Qty		or non-conformance	Ch	nief Eng	Description	on	Date	Verification	QC Inspector	
Design Doc/Data													
Equip/Tooling Handling/Pre		1 7. Y											
Material													
Operator	_									· [
Offset/Setup													
Process	_		··• <u>•</u> ,										
Supplier										1	<i>x</i> '		
Training	_				*			•			·		
Transport	_			1									
Unapproved				L		L					·	<u> </u>	
						FA	ULT CA	regory		·		· · · · · · · · · · · · · · · · · · ·	
Landing		į.	al and	·	General		1			10	:	Pressure/Forced	
	Bendi	_		-	Bend		Folio/Program			Outside Dimensions Over/Under tolerance		Set-up	
-	-	e Not Conce	ntric		BOM/Route		Grain			Part Incorrect		Temperature/Cure	
	Crack		h		Broken/Damage/Defect	_	Hardware			Part Lost/Missing		Weld	
	 '	/Kink/Ripple	e/wave	-	Burrs	_	Inspection Incomplete/Unqualified			Part Moved		Wrong Stock Pulled	
-	Cuffs	· •		\vdash	Countaging	_	Instructions Incomplete/Unclear			Positioned W	/rong		
	Crush	_		-	Countersink Cut Too Short		Misaligned/off center Mislabeled			Power Loss/S	· -	Other	
 	Heat		Tuba	-	Drawing		4		<u> </u>	1, 04461 50337.		Tourier	
	⊣ `	ction Strip ir s/Chatter	i iupe		Drill Holes	-	Misread Off-set				<u> </u>		
				\vdash	Finish	<u> </u>	-1	Calibration					
	_	ng Sequence		\vdash	Fit/Function	\vdash	-4	Sequence					
	Ivvave	/Twist in Tu	ne	L	Jrig runction		Journ						



DQA:		Date:عُدِّ أَنْ			CART									
		a a	i i		WORK ORDER NON	-CO	ONFO	RMANCE /	UPDAT		٠		AEROSPACE	
QA Closed:		Date:	í.							W	ork Order ür	odate only		
Work Order:	_	•	도 		DISPOSITION			W.	*** **AG	AINST DE	PARTMENT	/PROCESS		
					Rework]		Skid-tube	Cros	stube		Water Jet	Engineering #	
Part No.	1		e Tillion	·	Scrap]		Machining] Sma	all Fab	Pro	d. Eng. Coor.	Quality	
NCR No.					Use-as-is Suspected Unapproved		Thermoforming Finishing Composite				Rec/Stor	re/Packaging Supplier	Other	
Root		, .	4	Desc	ription of work order update		nitial		Action		Sign &			
Cause	Date	Step	Qty	***	or non-conformance	Ch	ief Eng	De	escription		~⊸ Date	Verification	QC (nspector	
Design Doc/Data	"	. •		•			A 7					. 4		
Equip/Tooling]						•		en en en en en en en en en en en en en e	. }		, war		
Handling/Pre]	ورنو				•	•			••			4	
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Operator			•		.		-						1	
Offset/Setup				:			*					and the second second		
Process					Appendix and the second	-	:							
Supplier		· _{Se}	,							*				
Training										<i>E. 41</i> ∙ 2			3	
Transport	_		14.	:3						ر تبر ا			Ì	
Unapproved	*	l i					<u> </u>				<u> </u>	<u> </u>		
				* · · · · · · · · · · · · · · · · · · ·		FA	ULI CA	TEGORY						
Landing	7		. v	,	General		1 v.	***			.	· (7p/r	
<u> </u>	Bending	· ·	X		Bend	-	4	Program	* V		Outside Dim		Pressure/Forced	
_	Centre No	ot Concen	itric 🚡	<i>i</i> -	BOM/Route	\vdash	Grain			_	Over/Under	• • –	Set-up	
	Cracks		3 3 6 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5		Broken/Damage/Defect	Ë	Hardwa	194	Training Sugar	ننا ،	Part Incorred	· —	Temperature/Cure Weld	
ja e	Crimp/Kir	ik/Ripple,	/Wave		Burrs	-	Inspection Incomplete/Unqualified Instructions Incomplete/Unclear				Part Lost/Missing			
1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	Cuffs	***		\vdash	Contamination	· · · · · · · · · · · · · · · · · · ·				<u> </u>	Part Moved * Wrong Stock Pulled Positioned Wrong			
	Crushing				Countersink .	Misaligned/off center				Positioned v	Other			
	Heat Trea		Tb	-	Cut Too Short	-	Mislabeled				Trower ross/	Juige	Tottiei	
·	Inspection	•	rube	\vdash	Drawing Drill Holes	\vdash	Misread Coff cot						<u> </u>	
	Marks/Ch Turning S			\vdash	Finish	-	Off-set Out of Calibration							
<u> </u>	Wave/Tw		ı c	\vdash	Fit/Function	\vdash	Out of Sequence						6	
ı İ	AAGACLIM	ISCHI TUD		1	I 19 I diletion	1	10000	JUNGUINUU				<u> </u>		